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RBT18520-9A
Job Sheet 193887



Part No: RBT18520-9A

Job Qty: 4 pcs

Part Name: Extension Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18520 Rev Q IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B 19.02.22 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	5/31/19		0.00	0.25	Small Fab - 1		DAS
							Small Fab - 2		71
							Small Fab - 3		9-89
							Small Fab - 4		
							Small Fab - 5		19-5-1
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	5/31/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		9-89 DAS 30 MAY 1 2019
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	4 pcs	5/31/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS 28 9-89
							Packaging 3 - 6 - B4B		



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Container No: S177188



Part: RBT18520-9A

Job No: 193887

Serial No/Batch: S177188

Revision: Q

Inspector:

Exp Date:

Instructions:

Date: 05/01/19

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				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - SA	4 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	DAS 21 3-69
								QC 21 - SA - 70	
								QC 21 - SA - 53	MAY 03 2019

Part Op 100 - Assemble as per drawing. See note 1.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91375A673	Socket Head Set Screw 7/16-14 X 1.5	4 Ea (1 ea)	100-Small Fab - 1	S044122
RBT18520-9	Extension	4 pcs (1 ea)	100-Small Fab - 1	S054832

0A050
145B

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91375A673	4	21	0
	RBT18520-9	4	7	0

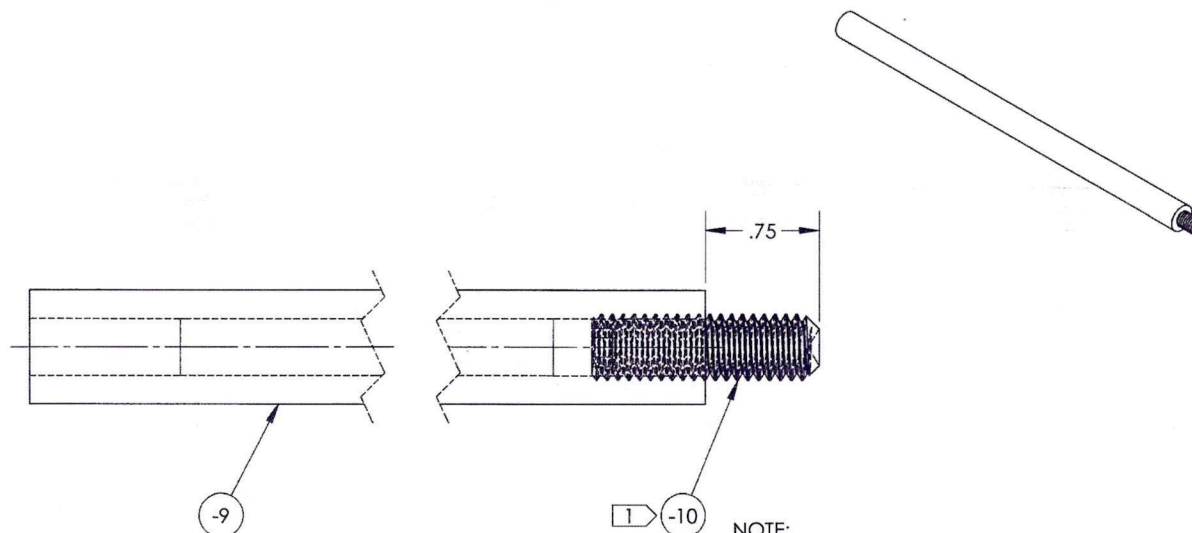
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		CHD P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2009	RJC	-
10	16-0096	-9A ADDED TO BOM.	8/4/2016	DPD	JAG
11	17-0069	-9A CHD LOCTITE NUMBER WAS 609 IS 262.	3/22/2017	DPD	JAG
Q		NOTE 1 CHANGED	2/19/2019	VM	VM



NOTE:

1) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -10 THEN ASSEMBLE WITH ITEM -9 AND REMOVE EXCESS, ALLEN HEAD IN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193887 MLW
1904-24

-9A

EXTENSION ASSEMBLY

DART AEROSPACE	
TITLE M/R DAMPER LOAD TEST DEVICE	
DWG NO. RBT18520-9A	REV Q
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/8$
HEAT TREAT	.XX $\pm .005$
FINISH FINISH	.XX $\pm .01$ ANGLES $\pm 1^\circ$
SPEC SPEC	.X $\pm .1$ SURFACES = 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: VM	
SCALE N/A	DATE 8/17/2000
SHEET 10 OF 17	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					